

UDAR


Work Order ID 82100

82100

March-22-12 3:02:19 PM

Item ID: D4018-041 Accept *N900040100* Setup Start *NS1*
Revision ID: Stop *NS2*
Item Name: Short Basket Lid Assembly (350)
Start Date: 3/22/12 Start Qty: 1.00 *1* Cust Item ID:
Required Date: 3/30/12 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan:  Date: Tooling: Date: Run Start *NR1*
QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4018	C

100 Weld per dwg A/R S.S. rod Batch: 118366 0.00

100 Large Fab Memo 0.00 Ppl 12.03.27 1x Ø

Large Fab 1- assemble ribs , weld as per dwg D4018 using DT9607B
2- weld hinge (3) and Mounting brackets as per dwg D4018
inspect before welding mesh
3- tack weld mesh on basket as per dwg D4018
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110 QC Memo 0.00 ll 1 Ø BEW/04/02

Quality Control

Work Order ID 82100

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120 *120* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
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130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 Memo *** mask sides of hinge prior to powdercoat*** Start Time: 2h15 Oven Temperature: 320°F Finish Time: 2h35	0.00 0.00							
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140 *140* HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 120059 Memo 1- Mask data plate and apply wing walk on outside surface of mesh as per dwg Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***	0.00							
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Scrubber

m117338

1 2P 12/04/03

1 BL 124-3.

Picklist Print

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Page 1

Work Order ID: 82100

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 3/22/12

Required Date: 3/30/12

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP RevA: new issue DD 09.11.30 verified by:EC
verified by:EC IPP Rev:C as per dwg RevB DD 10.04.16 verified by:EC
as per dwg revC DD 10.08.18 verified by:EC IPP Rev:D

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
✓ D4018-1 Rib		Manufactured	No			100	Each	5.0000	2	2		Pl 12.03.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		5							
				72545		5							
✓ D4018-3 Rib		Manufactured	No			100	Each	4.0000	2	2		Pl 12.03.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		4							
				73032		4							
✓ D4016-3 Hinge Half, Lid		Manufactured	No			100	Each	12.0000	3	3		Pl 12.03.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		12							
				78495		12							
✓ D4018-5 Rib		Manufactured	No			100	Each	27.0000	6	6		Pl 12.03.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA005		27							
				78041		27							
D4035-041 Lid Rib Assembly, Fwd (350 Basket)		Manufactured	No			100	Each	7.0000	1	1		Pl 12.03.27	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		6							
				63720		0							
				81701		6							
				WA006		1							
				74642		1							

Picklist Print

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Page 2

Work Order ID: 82100

Parent Item: D4018-041

Parent Item Name: Short Basket Lid Assembly (350)

Start Date: 3/22/12

Required Date: 3/30/12

Start Qty: 1.00

Required Qty: 1.00

✓ D4035-043 Manufactured No
Lid Rib Assembly, Aft (350 Basket)

100 Each 5.0000

1

1

PL 12.03.27

Location

Loc Qty

Loc Code

WA006

5

81201

5

①

✓ D2581 Manufactured No
Mounting Bracket

100 Each 15.0000

2

2

PL 12.03.27

Location

Loc Qty

Loc Code

WA005

15

69739

1

70766

2

77045

1

77523

11

②

✓ D4020-7 Manufactured No
Mesh (350 Basket Short, Lid)

100 Each 0.0000

1

1

382214 → ① PL 12.03.27

D4021-3 Manufactured No
Data Plate

100 Each 1.0000

1

1

381182 382214 → ① PL 12.03.27

Location

Loc Qty

Loc Code

WA005

1

75460

1

D2728-3 Manufactured No
Dart Logo label

140 Each 0.0000

1

1

115050.

1

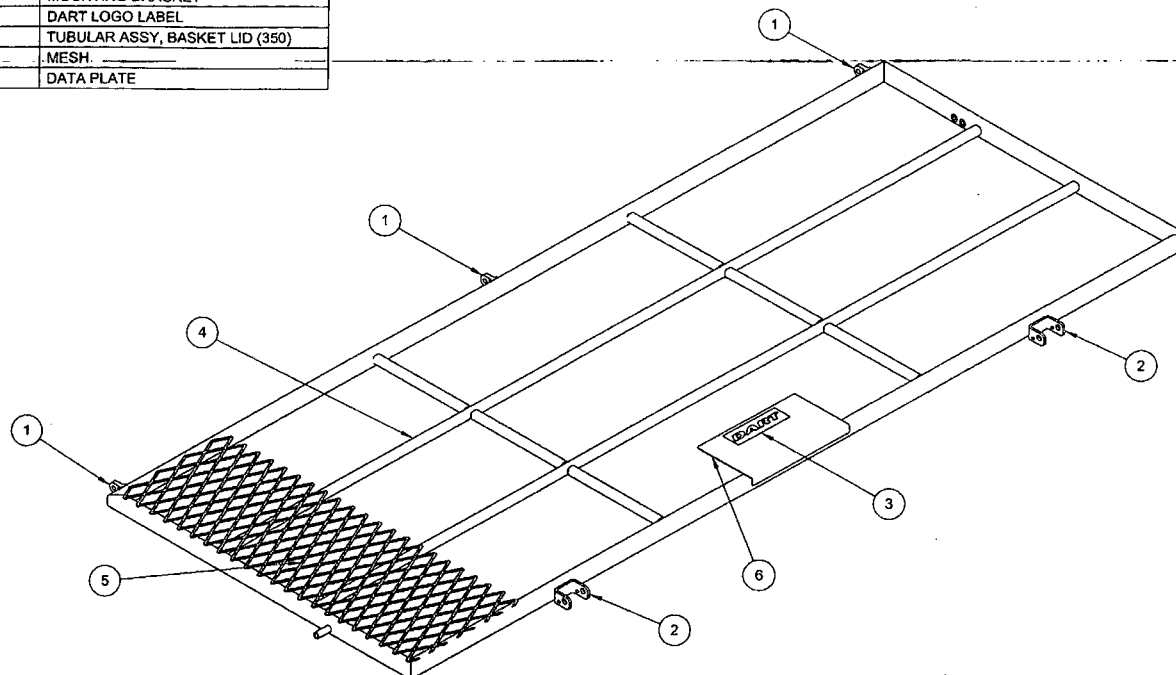
RD 12.4-3.

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Shop Packet Print

Page 2

ITEM	QTY -041	P/N	DESCRIPTION
	X	D4018-041	SHORT BASKET LID ASSY (350)
1	3	D4016-3	HINGE HALF, LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	1	D4018-101	TUBULAR ASSY, BASKET LID (350)
5	1	D4020-7	MESH
6	1	D4021-3	DATA PLATE

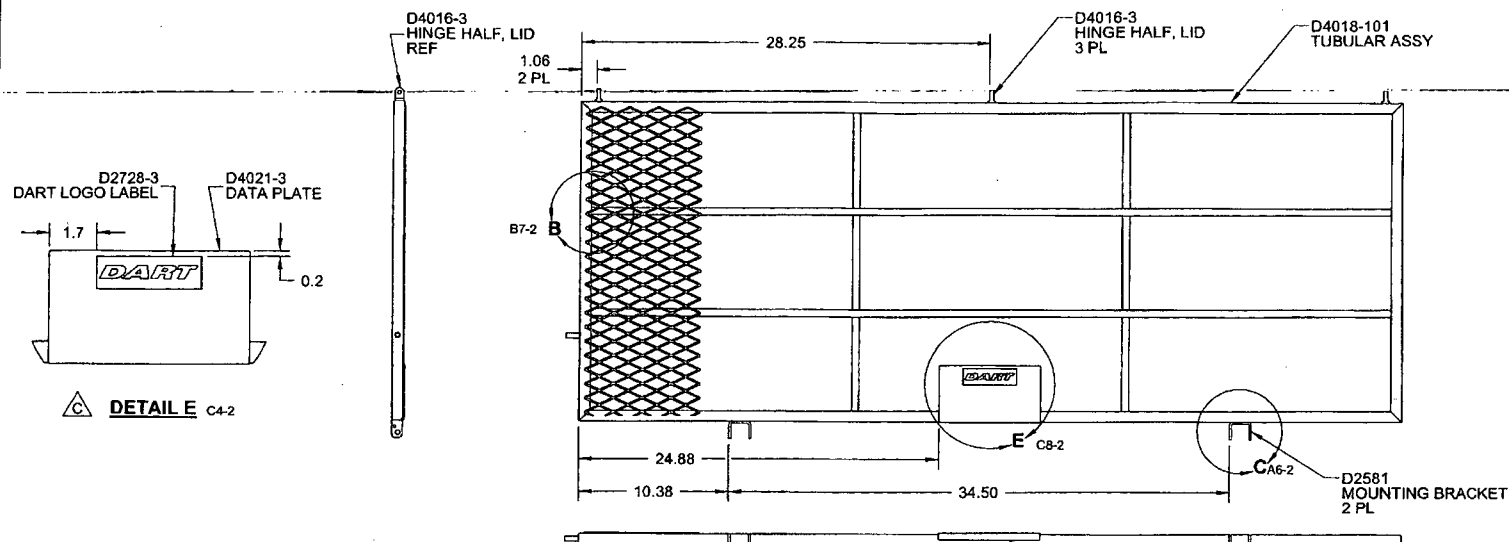


D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

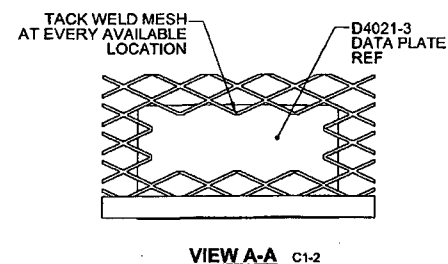
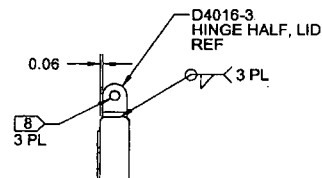
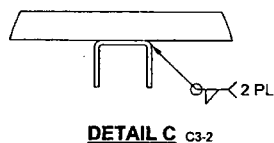
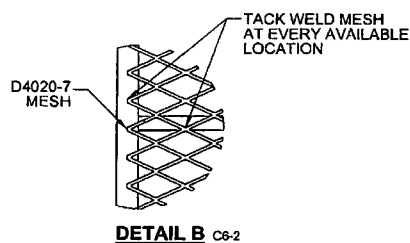
w/o 82100

RELEASED
10.08.12
ECN 10-96

C	REMOVED D4086-232, UPDATED DETAIL E ACCORDINGLY (C8-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
B	BOM: INSERTED QTY 1 D2728-3 AS ITEM 3 & QTY 1 D4086-232 PLACARD AS ITEM 7. ITEMS RENUMBERED AS REQD. SHEET 2, NOTES: PAINT SPEC ADDED & NOTE 7 & 8 REVISED. (84-2) FRONT VIEW ADDED, WELDING SYMBOLS REVISED. DETAIL VIEW E ADDED (C4-2)&(C82). SIDE VIEWS ADDED (C1-4)&(D1-4).	JPH	10.03.25
A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	AS		
APPROVED	AS		
DE APPR.	AS		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D4018 REV. C SHEET 1 OF 4 TITLE SHORT BASKET LID ASSY (350) SCALE NTS <small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>			



DETAIL E C4-2



D4018-041 SHORT BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.09.12

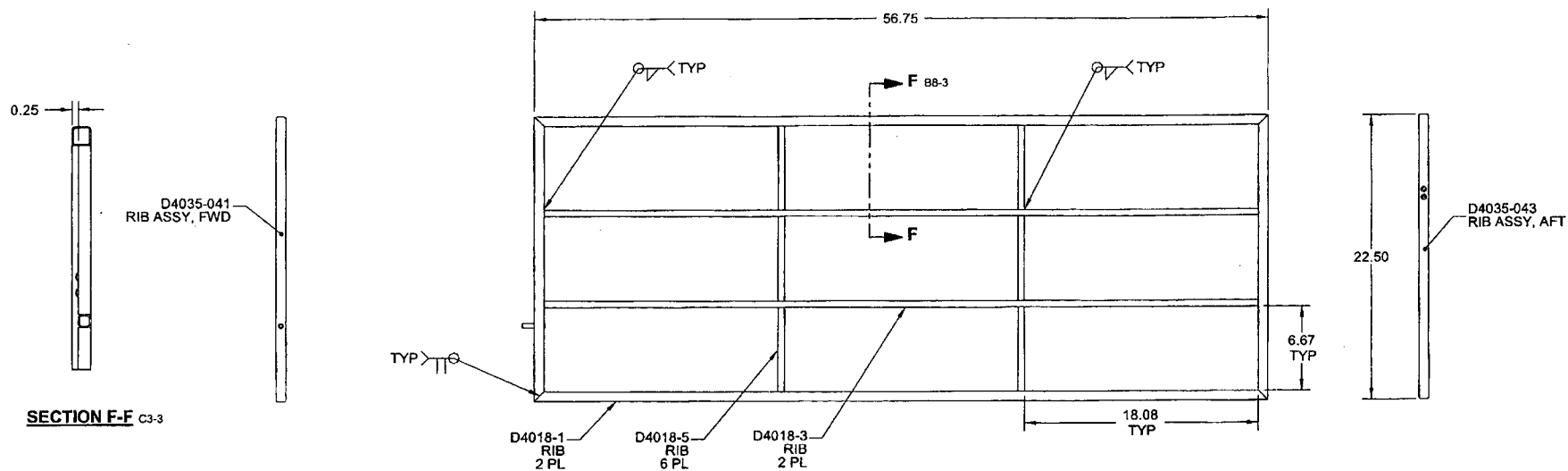
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.5 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DETAIL D D1-2

DESIGN	AKS	DART AEROSPACE LTD	
DRAWN	AKS	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	AKS	D4018	SHEET 2 OF 4
APPROVED	AKS	TITLE	SCALE
DE APPR.	AKS	SHORT BASKET LID ASSY (350)	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D4018-101	TUBULAR ASSY, BASKET LID (350)
1	2	D4018-1	RIB
2	2	D4018-3	RIB
3	6	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



8 D4018-101 TUBULAR ASSY, BASKET LID (350)

RELEASED
10.08.12 UP

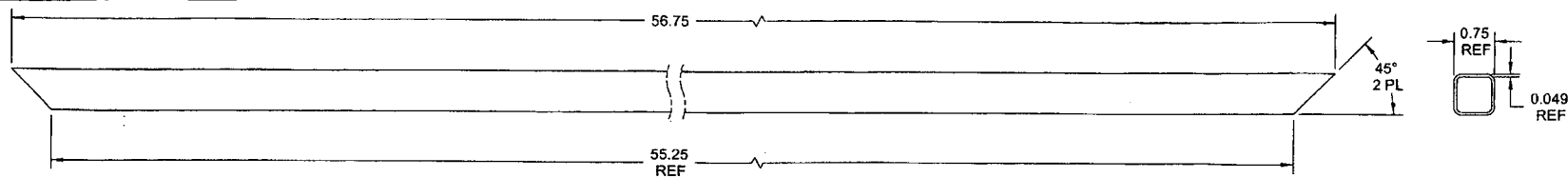
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 9.06 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN	SC	HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	REV. C
MFG. APPR.	SC	D4018	SHEET 3 OF 4
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	SHORT BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

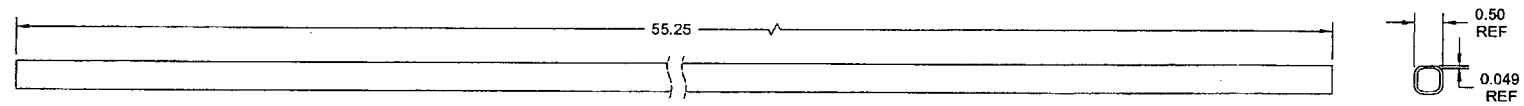
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D



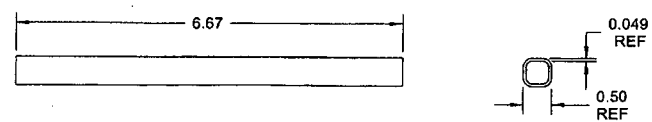
D4018-1 RIB

C



D4018-3 RIB

B



D4018-5 RIB

A

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-3 & -5: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 UP

DESIGN	115	DART AEROSPACE LTD	
DRAWN	h	HAWKESBURY, ONTARIO, CANADA	
CHECKED	h	DRAWING NO.	REV. C
MFG. APPR.	h	D4018	SHEET 4 OF 4
APPROVED	h	TITLE	SCALE
DE APPR.	h	SHORT BASKET LID ASSY (350)	NTS
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8 7 6 5 4 3 2 1